

Thursday, April 12, 2012 12:38:13 PM


Accept

83012

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

5

6

Cust Item ID:

6

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

100	Small Fab	0.00	3X	12/05/14
100				
Small Fab	Memo	0.00		
Small Fab	Assemble as per dwg D3531			
110	QC5- Inspect part completeness to step on W/O	0.00	3	12/05/14
110				
QC	Memo	0.00		
Quality Control				
120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00	3X	12/05/14
120				
Powdercoat	Memo	0.00		
Powder Coating	START TIME: 1:50			
	FINISH TIME: 2:20			

M117338

W/O: 83012		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3531-041 PAR #: _____ Fault Category: Small Tab NCR: Yes ☒ No ☐ DQA: 12/05/23 Date: 12/05/23
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 12/5/23

NCR: 12-11479		WORK ORDER NON-CONFORMANCE (NCR) 75.66						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/05/14	100	1 part was scrap at the riveting when removed rivet hole enlarge K.C process	1205.14 Q51042	Scrap - destroy No replace	12/05/14	2A 12/05/14	1205.14 Q51042	12/05/15

NOTE: Date & initial all entries

Work Order ID 83012

83012

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Item ID: D3531-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket Assembly
 Start Date: 4/12/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 4/24/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location <u>227</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

12/5/15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 83012

83012

Parent Item: D3531-041

D3531-041

Parent Item Name: Bracket Assembly

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3531-1 *D3531-1* Bracket		Manufactured	No			100	Each	1.0000	1	6			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				1					
					77700			1					
D3531-3 *D3531-3* Bracket Front Plate		Manufactured	No			100	Each	1.0000	1	6			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				1					
					61781			0					
					71978			1					
MS20470AD4-4 *MS20470AD4-4* Rivet, Universal Head		Purchased	No			100	Each	3,678.000	12	72			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST319				3678					
					116188			136					
					116391			66					
					118614			1087					
					119109			26					
					120361			1858					
					121011			505					

GP 12/05/14
B83013 4x

GP 12/05/14
B83014 4x

GP 12/05/14

48

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

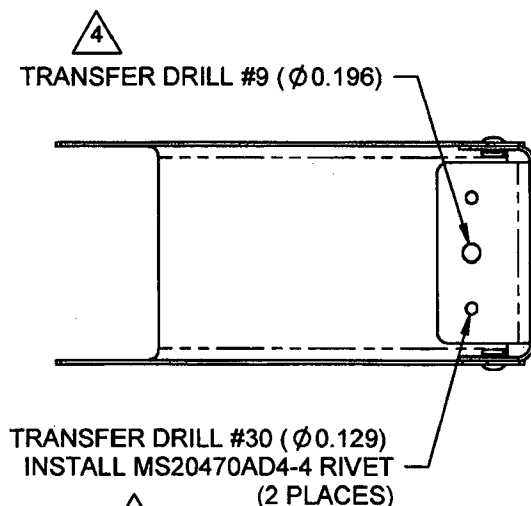
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

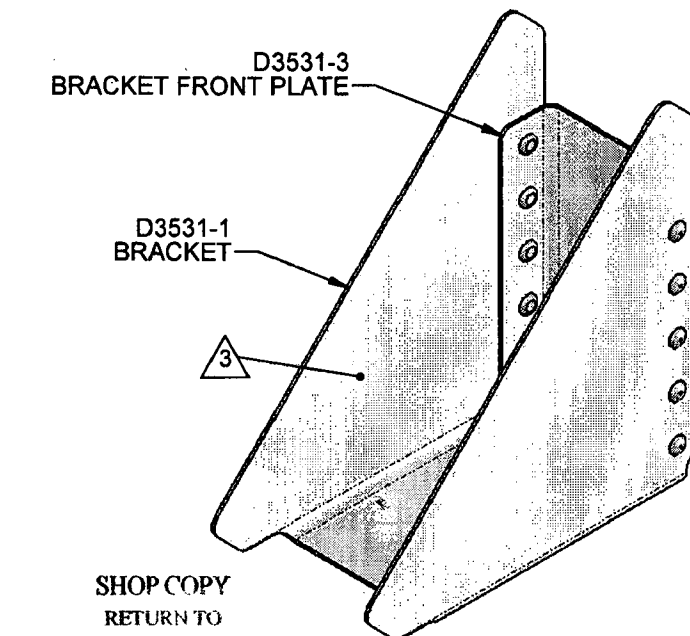
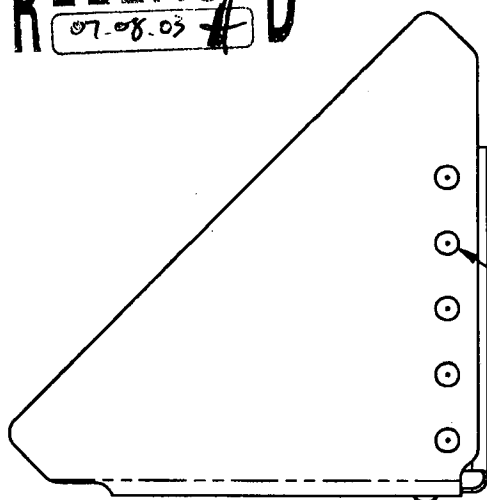
NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	

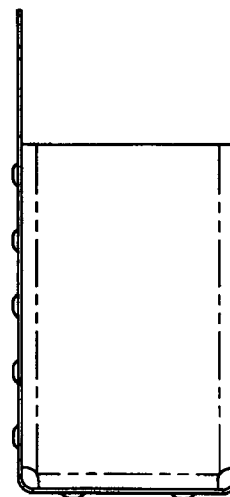


RELEASED
07-08-03



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83012

MS20470AD4-4
(10 PLACES)



D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

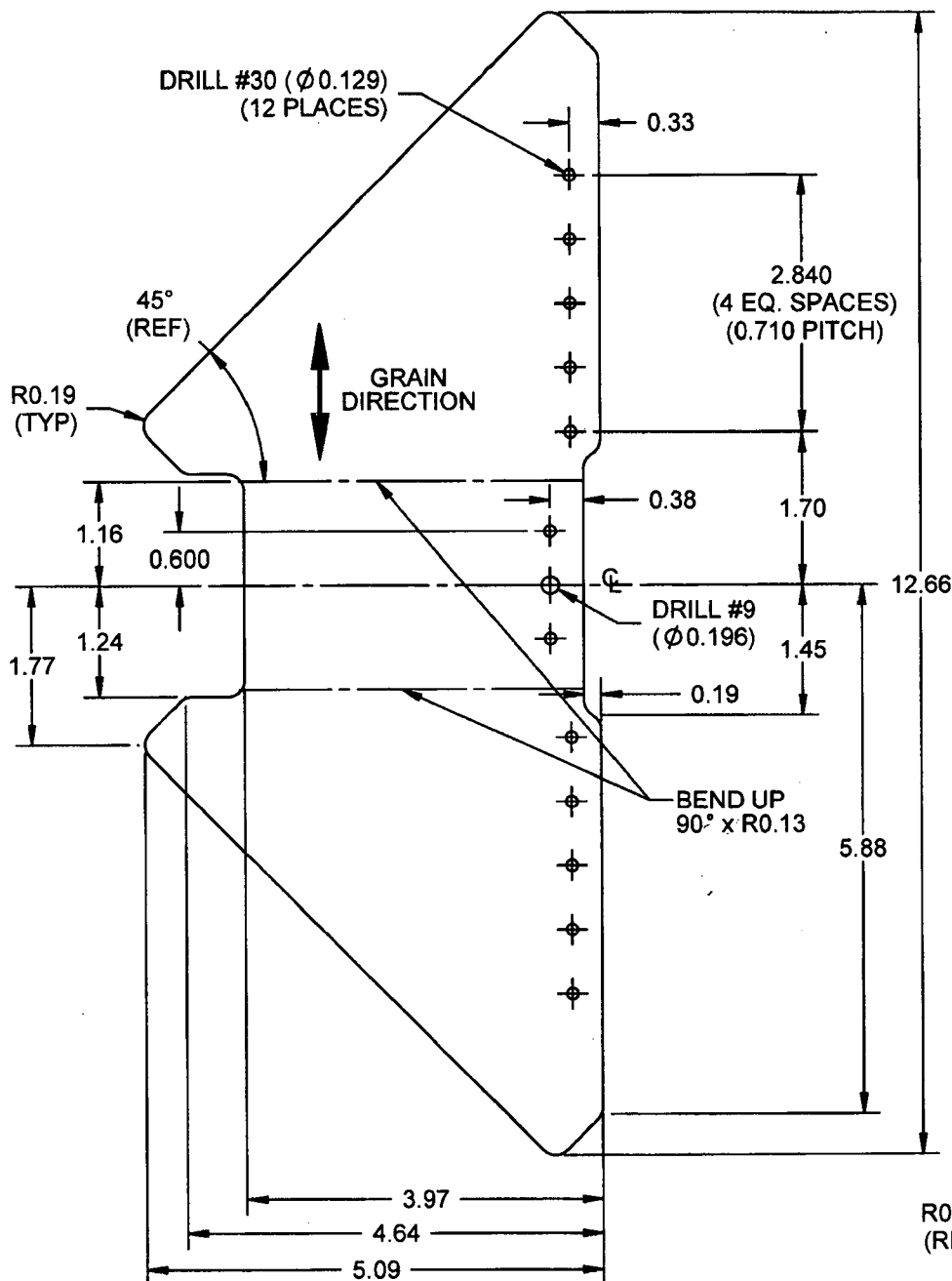
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

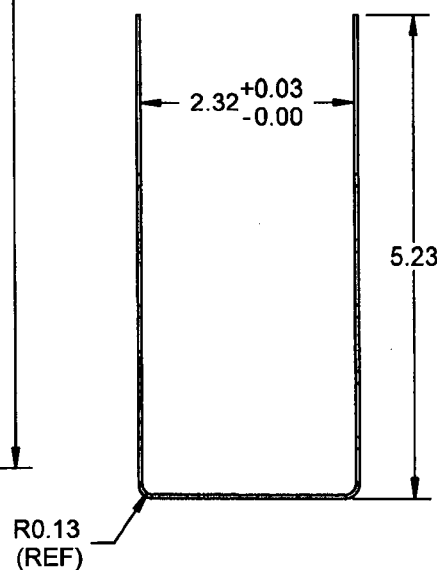
NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED <i>[Signature]</i>	DRAWING NO. D3531	REV. A
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SHEET 2 OF 3 SCALE 1:2



RELEASED
07.08.03



D3531-1F FLAT PATTERN

D3531-1 BRACKET

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

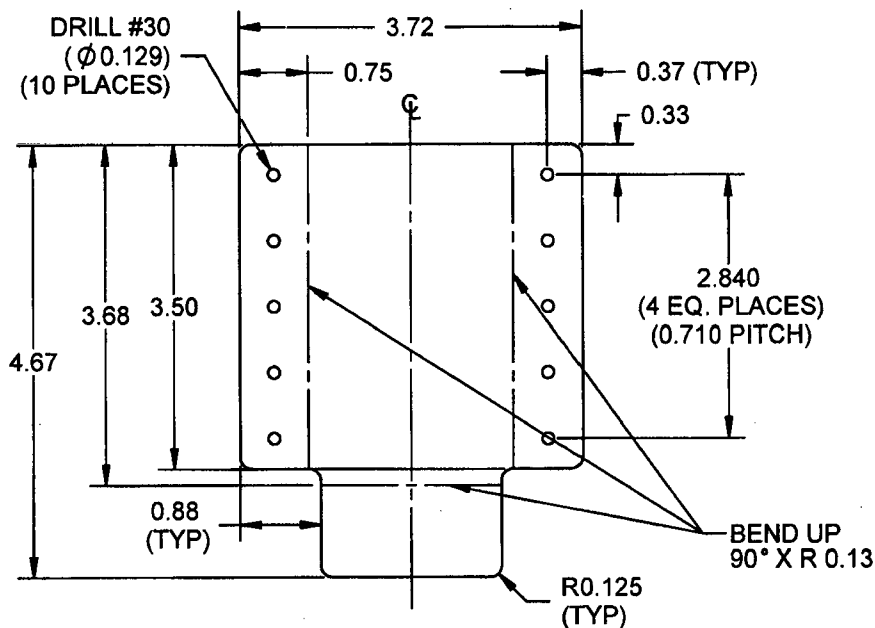
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

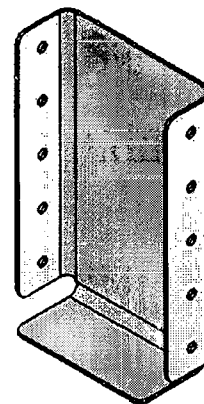


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3531	REV. A
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SHEET 3 OF 3 SCALE 1:2

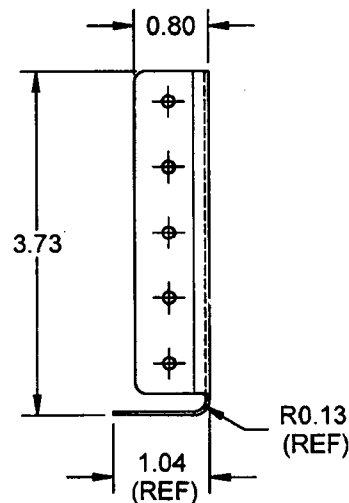
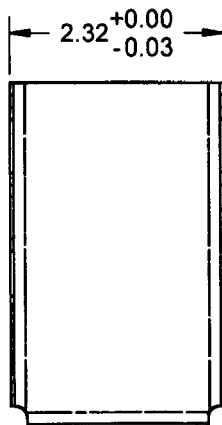


D3531-3F FLAT PATTERN

RELEASED
07.08.03



83012



D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries